



Repair Standards

01-003 – Swing Door Repairs

Disclaimer:

Only a certified and experienced person using suitable tools should complete the repairs described below. Repairs should meet or exceed manufacturer's minimum specifications and should be in agreement with all safety and ecological regulations.

Permissible upon return and does not require repair:

- Acceptable repairs.

Requires repair upon return:

- Cuts, tears or holes in the door skin/door panel, large or small.
- Rotten door panels due to corrosion/moisture.

Restrictions:

- Sections the width of the door is unacceptable.
- Sections/replacements must be the same width as the original door panel. Sections can be cut from a door blank or plywood (provided that it's the same thickness).
- Caulk should NOT be put around the outside of a torn hinge repair.

Procedure:

1. Minor cuts/tears:

- 1) Using the correct silicone color, fill-in and smooth the cut.

2. Major cuts/tears:

- 1) Using silicone, fill-in the damaged area and install a patch with .50 aluminum material. The patch should be fastened, with 3/16" or 1/4" self-sealing pop rivets on 1-1/2" centers, carefully to be sure that the drill bit does not penetrate the door panel.
- 2) Sealant should be applied directly behind the repaired patch area.

3. Torn Hinges:

- 1) Remove damaged portion of door panel
- 2) Using an appropriately thick sheet of plywood (or door blank), cut out a piece to replace the damaged area.
- 3) Cut two .050 aluminum panel pieces to cover and support the repair area, leaving an excess of 2" on each side.



- 4) Replace the damaged area with the new piece of wood.
- 5) Seal the edges of the repair to form a water-tight fit before placing the cut .050 aluminum panels and clamping into place.
- 6) Be sure that the .050 aluminum panels fit true to the inside of the door seal, as well as being centered from top to bottom. Be sure that the aluminum is NOT enclosed behind the door seal.
- 7) With the head of the bolt/rivet facing in, bolt/rivet through the .050 aluminum panels and door panel.
- 8) Be sure that fasteners are on 2" centers and offset ½" from the .050 aluminum panels. Excess bolts should be cut off and ground smooth and true with the nut.
- 9) Re-apply the hinge by bolting through the panels and new core.

Finished Product

Interior – Swing Door Hinge Section



4. Corner Section:

NOTE: Corner sections should not exceed the height of 18", measured from the bottom of the door.

No more than two corner sections should be on one door panel.

- 1) Cut out the damaged door corner.
- 2) Using an appropriately thick sheet of plywood (or door blank), cut out a piece to replace the damaged corner.
- 3) Cut two .050 aluminum panel pieces to cover and support the repair area, leaving an excess of 2" on each side.



- 4) Replace the damaged area with the new piece of wood, securing it with nails in the corners.
- 5) Using the appropriate colored caulking spread it on the edges of the old door panel and the outer ends of the replacement.
- 6) Using the .050 aluminum panel, cut out in step three, fit them on both sides and clamp into place. Be sure that the sections are true to the edge of the door seal.
- 7) Fasteners should be placed on all three sides, ½" from the edge.
- 8) Fasteners should be placed on 2" centers where the new and old door panels meet. These should be offset by 1" inside the new door panel.
- 9) Using ¼" overhead door rivets, 3/16" x 1 1/8" soft buck-rivets or ¼" rib-neck bolts, re-attach any hinges that may need to be put back in the repaired area.
- 10) Dispose of any extra bolts and smooth the area. It is not necessary to caulk the outside of the repaired area.